

Date: Wednesday, 06/09/2006 11:05:29 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 28426
 Estimate Number : 12524
 P.O. Number :
 This Issue : 06/09/2006 S.O. No. :
 Prsh't Rev. : NC
 First Issue : / / Type : SMALL /MED FAB
 Previous Run :
 Written By : *EC*
 Checked & Approved By :
 Comment : Est Rev:A New Issue 06-09-06 EC

Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S050	2024-T3 .050 sheet 
		Comment: Qty.: 0.2048 sf(s)/Unit Total : 0.4095 sf(s) <i>2024-T3-050 sheet</i> <i>Batch: M119053</i>
2.0	WATER JET	FLOW WATER JET 
		Comment: FLOW WATER JET <i>1-Cut as per Dwg D3534</i> <i>Dwg Rev: Preliminary</i> <i>Prog Rev: Preliminary</i> <i>M 06 09 06</i> <i>(2)</i>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>M 06 09 02</i> <i>(2)</i>
4.0	QC8	SECOND CHECK 
		Comment: SECOND CHECK <i>EC 06.09.06</i> <i>(2)</i>
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 
		Comment: SMALL & MEDIUM FAB RESOURCE 1 <i>EC 06.09.06</i> <i>(2)</i>
		Deburr if necessary.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 06/09/2006 11:05:30 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 28426

Part Number: D35341

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Q.M 06-09-07

②

7.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

E 06-09-14

②

8.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock for eng. use only

Location: _____

E 06-09-14

②

9.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: Inspection Level 21

207/03/08

②

Job Completion



E 06-09-10

Eng Approval

CB 07.03.08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PRELIMINARY ISSUE

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED	DRAWING NO. D3534	REV. A	SHEET 1 OF 1
DATE 06.07.14		TITLE DOUBLER	SCALE	1:1
A	06.07.14	NEW ISSUE		

5.25

5.34

R0.25
(TYP)

D3534-1 DOUBLER

UNDER REVIEW

06.08.22 CB

prototype

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM 0.050" THICK (QQ-A-250/5 OR AMS 4037)
(REF DART SPEC M2024T3S.050)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DART AEROSPACE LTD	Work Order:	28426
Description:	Part Number:	3534-1
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Measured by:	MM	Audited by:	E	Prototype Approval:	CB
Date:	16.03.08	Date:	06.09.08	Date:	07.03.08

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

CERTIFIED INSPECTION REPORT

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet. Per:

Mark J. Vrablic
Mark J. Vrablic
Director of Manufacturing Davenport Works

Kerton P. Young
Kerton P. Young
Quality Assurance Manager

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS

Ship From: RIVERDALE, IA.

Page 1

391671	101057	Invoice No.	Alcoa No. Item
Ship Date	P.L. No.		
2005-04-12	73600	06261	DCE10111-5
P.O. No./Govt Contract No.	Customer		
N17105	SAMUEL SON-MISSION		

Ship To: SAMUEL, SON & CO. LIMITED,
2360 DIXIE ROAD,
MISSISSAUGA, ON. L4Y 1Z7

ITEM Description
.050 IN TK X 48 IN W (N) A/T 2024-T3 COILED SHEET MILL FINISH. PER AMS-QQ-A-250/4 REV A PER AMS4037 REV N, PER
ASTM208 REV 04 ((NOT MARKED)) COIL SIZES:
ID-20 IN COIL WTGS: MAX 4500 LB PKG WTG: 5000
LB EXPORT PACK QUAN TOL +/-40 %
CQR 0155764 REV 01 CUST REQ 05-04-02 *** W/E 05-04-16 ***

Num	Package	Ticket	Lot	Weight	Quantity	UOM	Po Id/Serl
1			347531	3071	1	PC	0404143
2			347531	3941	1	PC	0404144
				7012	2		

Notes for CQR: 0155764.1
PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF AMS-QQ-A-250/4 ALSO MEETS THE REQUIREMENTS OF QQ-A-250/4E, AMENDMENT 2.
PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF QQ-A-250/4E AMENDMENT 2 ALSO MEETS THE REQUIREMENTS OF AMS-QQ-A-250/4.

CQR: 0155764.1 -Specification Limits

Temp	Dir	UTS			TYS			EL4D			
		KSI	KSI	PCT	KSI	KSI	PCT	Other	Other	Total	Aluminum
T3	Long Transv.	Max	63.0	42.0	15						
		Min	63.0	42.0	15						
Chemical Composition	Alloy 2024	Max	SI	FE	CU	MN	MG	CR	ZN	TI	Each
		Min	.50	.50	4.9	.9	1.8	.10	.25	.15	.05
Alloy 2024	Alloy 2024	Max									REMAIN
		Min									

Lot: 347531 -Mechanical, Physical, Metallography, Quantometer Results

Temp	Dir	No.			UTS			TYS			EL4D		
		Test	KSI	KSI	KSI	KSI	PCT	PCT	PCT	PCT	PCT		
T3	Long Transv.	2	Max	67.9	47	18.5							
		Min	67.8	46.1	17.4								

Alcoa QA Dept

Date	11-14-05
Cust	Sam
W/O #	172854
Qty.	70 Pcs. 2
<input type="checkbox"/> Size	<input type="checkbox"/> Special Instructions
<input type="checkbox"/> Part #	<input type="checkbox"/> All <input type="checkbox"/>
These test reports are for on your PO# 100000008 From Copper	
<i>Tashan Durham</i> Quality Representative	
Customer Part #	